

Work Order ID 58659

Thursday, May 13, 2010 10:26:09 AM



Page 1

Item ID: D3914-041

Accept



Setup Start



Revision ID:

Item Name: Long Basket Lid Assembly (350)

Stop



Start Date: 5/13/2010 Start Qty: 1.00



Cust Item ID:

Required Date: 5/19/2010 Req'd Qty: 1.00



Customer:

Reference:

Approvals:

Process Plan: MF

Date: 10-5-13 Tooling:

Date:

Run Start



QC:

Date:

SPC (Y/N):

Date:

Stop



Sequence ID/
Work Center ID

Operation
Description

Set Up/
Run Hours

Draw
Number

Draw
Rev.

Plan
Code

Accept
Qty

Reject
Qty

Reject
Number

Insp.
Stamp

Draw Nbr

Revision Nbr

D3914

A

100



Large Fab

Large Fab

Weld per dwg A/R S.S. rod Batch: 111679 0.00
Large Fab

Memo

0.00

1- assemble ribs , weld as per dwg D3914 using DT9607A
2- weld hinge (3) and Mounting brackets as per dwg D3914
inspect before welding mesh
3- tack weld mesh on basket as per dwg D3914
***make sure to place mesh correctly on lid, check with label plate before
tacking mesh***

RPL 10.05.17

110



QC

Quality Control

QC9- Inspect visual per QSI004- Fusion Welds ✓ 0.00

Memo

0.00

PD 10.05.19

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

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Date:

Run Start

QC:

Date:

SPC (Y/N):

Date:

Stop

Sequence ID/
Work Center IDOperation
DescriptionSet Up/
Run HoursDraw
NumberDraw
Rev.Plan
CodeAccept
QtyReject
QtyReject
NumberInsp.
Stamp

120



QC

Quality Control

QC5- Inspect part completeness to step on W/O

0.00

8:00/20

Memo

0.00

①

130



Powdercoat

Powder Coating

Black Sandtex(Ref:4.3.5.7) per QSI005 4.3

0.00

Start 8:45 AM
Fin 320°F
temp 8:15 AM

Memo

0.00

EU 10/05/20 1 ①

140



HandFinish

Hand Finishing

Wing Walk as per dwg QSI005 4.4 Batch 114432

0.00

Memo

0.00

1- Mask data plate and apply wing walk on outside surface of mesh as per dwg

2- Install placard and label as per dwg

① 8:50/05/20 ①
① 10/05/20 ①

① BR 10-5-20

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Date:

Run Start



QC:

Date:

SPC (Y/N):

Date:

Stop

Sequence ID/
Work Center IDOperation
DescriptionSet Up/
Run HoursDraw
NumberDraw
Rev.Plan
CodeAccept
QtyReject
QtyReject
NumberInsp.
Stamp

150



QC3- Inspect Part Finish

0.00

QC

Memo

0.00

Quality Control

SD 10/05/20

②

160



Identify as per dwg & Stock Location: _____

0.00

Packaging

Memo

0.00

Packaging

B 58775

SD 10/05/20

170



QC21- Final Inspection - Work Order Release

0.00

QC

Memo

0.00

Quality Control

10/05/20
u 10.05.20

Dart Aerospace Ltd

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Picklist Print

Thursday, May 13, 2010 10:26:08 AM

Page 1

Work Order ID: 58659

Parent Item: D3914-041

Parent Item Name: Long Basket Lid Assembly (350)

Comments: IPP Rev:A new issue DD 10.03.19 verified by:EC

Start Date: 5/13/2010

Required Date: 5/19/2010

Start Qty: 1.00


Required Qty: 1.00


Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Qty Issued	Date Issued	Status
---------------------------------	------------------------	---------------	-------------	---------------------	------------------	-----------------	--------------------	----------------	-------------	---------------	----------------	--------


D2581  Mounting Bracket		Manufactured	No			100	Each	36.0000	2			
--	--	--------------	----	--	--	-----	------	---------	---	--	--	--

 SAO 10-05-73

Location	Loc Qty	Loc Code
WA	36	
46086	2	
51745	2	
57185	9	2
58301	23	


D2728-3  Dart Logo label		Manufactured	No			140	Each	0.0000	1			
---	--	--------------	----	--	--	-----	------	--------	---	--	--	--

 SAO 10-05-20

D3914-1  Rib		Manufactured	No			100	Each	6.0000	2			
---	--	--------------	----	--	--	-----	------	--------	---	--	--	--

 SAO 10-05-13

Location	Loc Qty	Loc Code
WA	6	
58241	2	2
58585	4	

D3914-7  Rib		Manufactured	No			100	Each	4.0000	2			
---	--	--------------	----	--	--	-----	------	--------	---	--	--	--

 SAO 10-05-13

Location	Loc Qty	Loc Code
WA	4	
58242	4	2

W/O:		WORK ORDER CHANGES					
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Page 2

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Parent Item Name: Long Basket Lid Assembly (350)

Comments: IPP Rev:A new issue DD 10.03.19 verified by:EC

Start Date: 5/13/2010

Required Date: 5/19/2010

Start Qty: 1.00


Required Qty: 1.00

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Qty Issued	Date Issued	Status
---------------------------------	------------------------	---------------	-------------	---------------------	------------------	-----------------	--------------------	----------------	-------------	---------------	----------------	--------

D4016-3		Manufactured	No			100	Each	19.0000	3			
												
Hinge Half, Lid												


Location Loc Qty Loc Code

ST109	7	
57574	7	3
ST116	12	
58243	12	

D4018-5		Manufactured	No			100	Each	12.0000	9			
												
Rib												


Location Loc Qty Loc Code

WA	12	B58594 6
58244	12	3

D4020-5		Manufactured	No			100	Each	2.0000	1			
												
Mesh (350 Basket Long, Lid)												

Location Loc Qty Loc Code

WA	2	
58245	2	①

D4021-3		Manufactured	No			100	Each	3.0000	1			
												
Data Plate												

Location Loc Qty Loc Code

WA	3	
56050	1	
58246	2	1

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Page 2

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Parent Item: D3914-041



Parent Item Name: Long Basket Lid Assembly (350)

Start Date: 5/13/2010

Required Date: 5/19/2010

Comments: IPP Rev:A new issue DD 10.03.19 verified by:EC

Start Qty: 1.00

Required Qty: 1.00

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Qty Issued	Date Issued	Status
D4035-041 Lid Rib Assembly, Fwd (350 Basket)		Manufactured	No			100	Each	2.0000	1		SAD 10-05-12	
				<u>Location</u>			<u>Loc Qty</u>	<u>Loc Code</u>				
				WA			2					
					58192		2					
D4035-043 Lid Rib Assembly, Aft (350 Basket)		Manufactured	No			100	Each	2.0000	1		SAD 10-05-12	
				<u>Location</u>			<u>Loc Qty</u>	<u>Loc Code</u>				
				WA			2					
					58193		2					
D4086-210 Placard, Max Load		Manufactured	No			140	Each	4.0000	1			
				<u>Location</u>			<u>Loc Qty</u>	<u>Loc Code</u>				
				ST112			4					
					56978		4					

SAD 10-05-12

Thursday, May 13, 2010 10:26:09 AM

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Page 3

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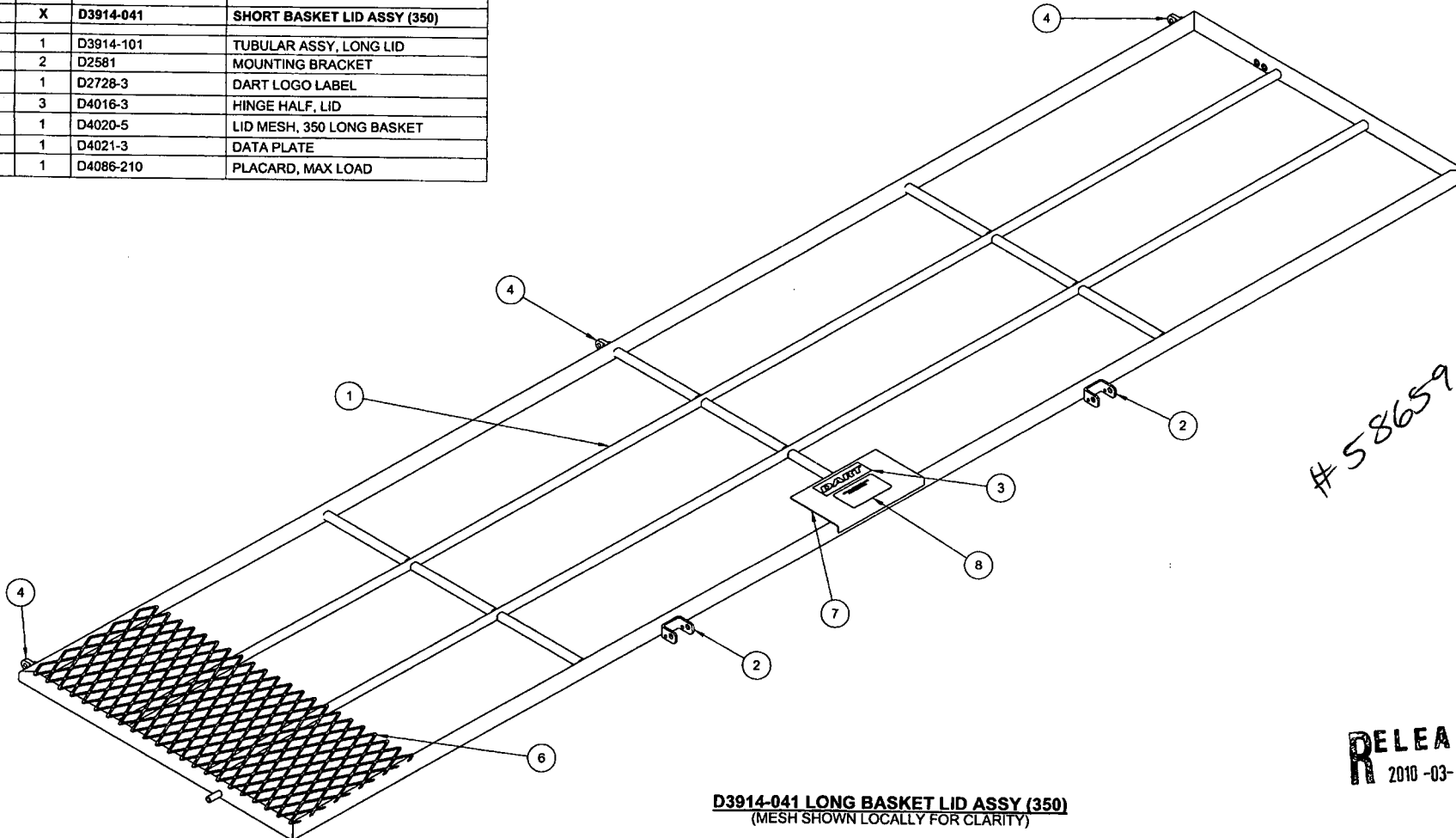
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ITEM	QTY	P/N	DESCRIPTION
	X	D3914-041	SHORT BASKET LID ASSY (350)
1	1	D3914-101	TUBULAR ASSY, LONG LID
2	2	D2581	MOUNTING BRACKET
3	1	D2728-3	DART LOGO LABEL
4	3	D4016-3	HINGE HALF, LID
6	1	D4020-5	LID MESH, 350 LONG BASKET
7	1	D4021-3	DATA PLATE
8	1	D4086-210	PLACARD, MAX LOAD



#58659

D3914-041 LONG BASKET LID ASSY (350)
(MESH SHOWN LOCALLY FOR CLARITY)

RELEASED
2010-03-22

REV. A	NEW ISSUE	JPH	10.03.16
DESIGN	AJS	DESCRIPTION	
DRAWN	JPH	BY	DATE
CHECKED		DART AEROSPACE LTD	
MFG. APPR.		HAWKESBURY, ONTARIO, CANADA	
APPROVED		DRAWING NO.	REV. A
DE APPR.		D3914	SHEET 1 OF 4
DATE	10.03.16	TITLE	SCALE
		LONG BASKET LID ASSY (350)	NTS
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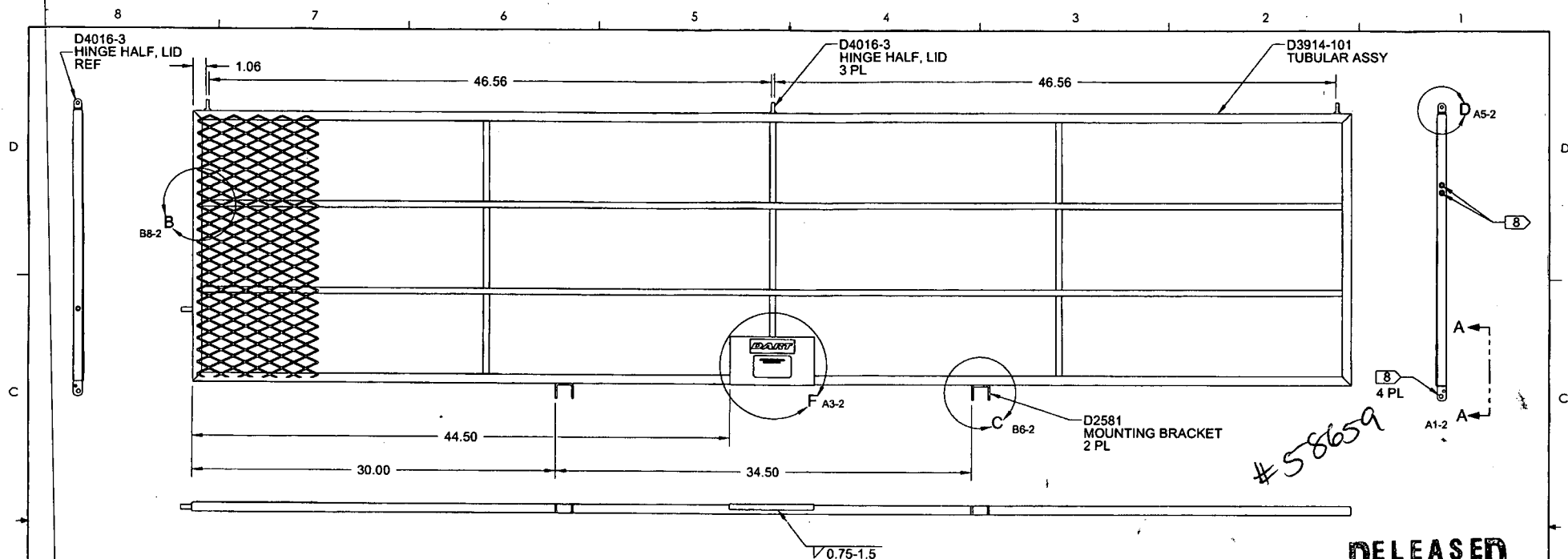
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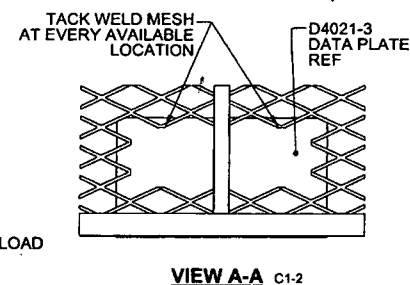
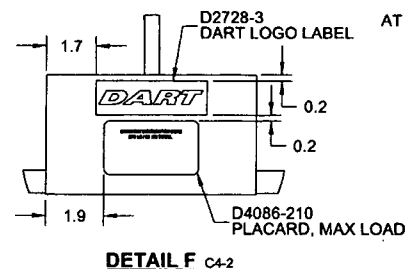
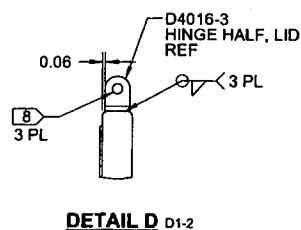
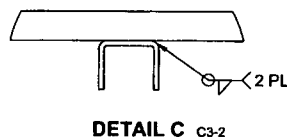
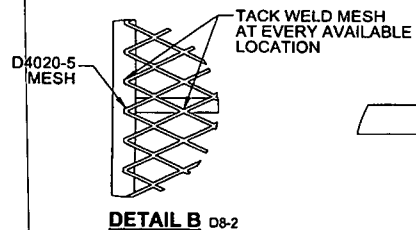
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NOTE: Date & initial all entries



D3914-041 LONG BASKET LID ASSY (350)
(MESH SHOWN LOCALLY FOR CLARITY)



NOTES:

- 1) MATERIAL: N/A
- 2) FINISH: POWDER COAT BLACK SANDTEX (4.3.5.7) PER DART QSI 005 4.3
APPLY BLACK ANTI-SKID PAINT TO OUTSIDE SURFACE OF MESH PER DART QSI 005 4.4
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: N/A
- 6) IDENTIFICATION: N/A
- 7) WEIGHT: 22.35 lbs APPROX
- 8) MASK HOLES PRIOR TO FINISHING
- 9) WELD PER DART QSI 004

DESIGN	AJS	DART AEROSPACE LTD	
DRAWN	JPH	HAWKESBURY, ONTARIO, CANADA	
CHECKED		DRAWING NO.	REV. A
MFG. APPR.		D3914	SHEET 2 OF 4
APPROVED		TITLE	SCALE
DE APPR.		LONG BASKET LID ASSY (350)	NTS
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RELEASED
2010-03-22

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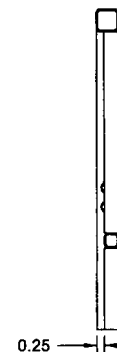
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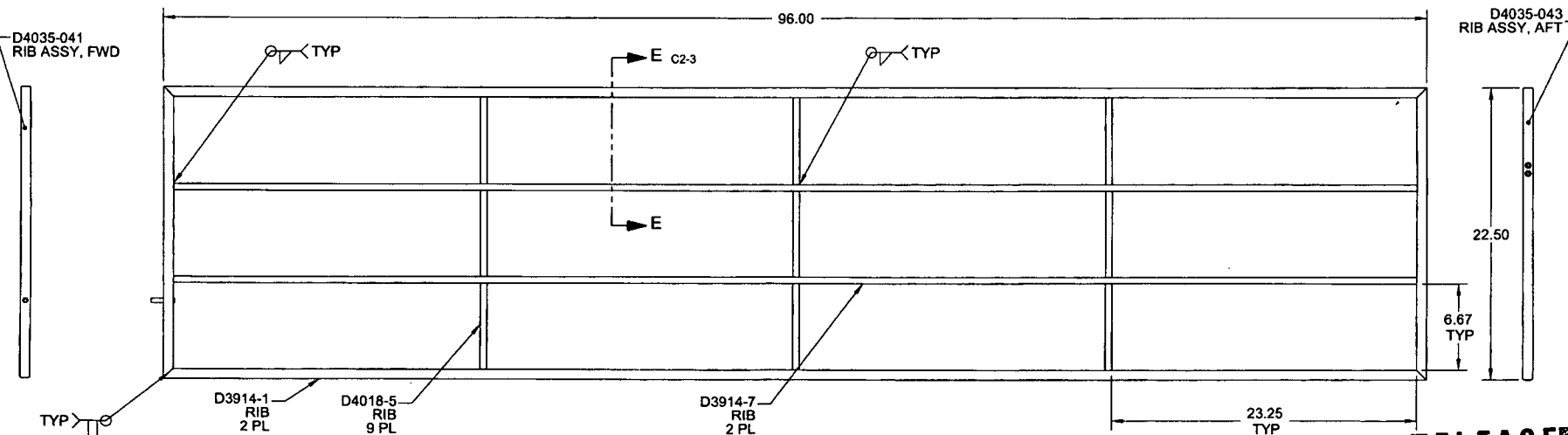
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ITEM	QTY -101	P/N	DESCRIPTION
	X	D3914-101	TUBULAR ASSY, BASKET LID (350)
1	2	D3914-1	RIB
2	2	D3914-7	RIB
3	9	D4018-5	RIB
4	1	D4035-041	BASKET LID RIB ASSY, FWD
5	1	D4035-043	BASKET LID RIB ASSY, AFT



SECTION E-E C5-3



8 D3914-101 TUBULAR ASSY, LONG LID

RELEASED
2010-03-22
AWP

NOTES:

- 1) MATERIAL: N/A
- 2) FINISH: NONE
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: N/A
- 6) IDENTIFICATION: N/A
- 7) WEIGHT: 14.10 lbs
- 8) TOLERANCE FOR XX.XX DIMENSIONS ± 0.06 FOR D4018-101
- 9) WELD PER DART QSI 004

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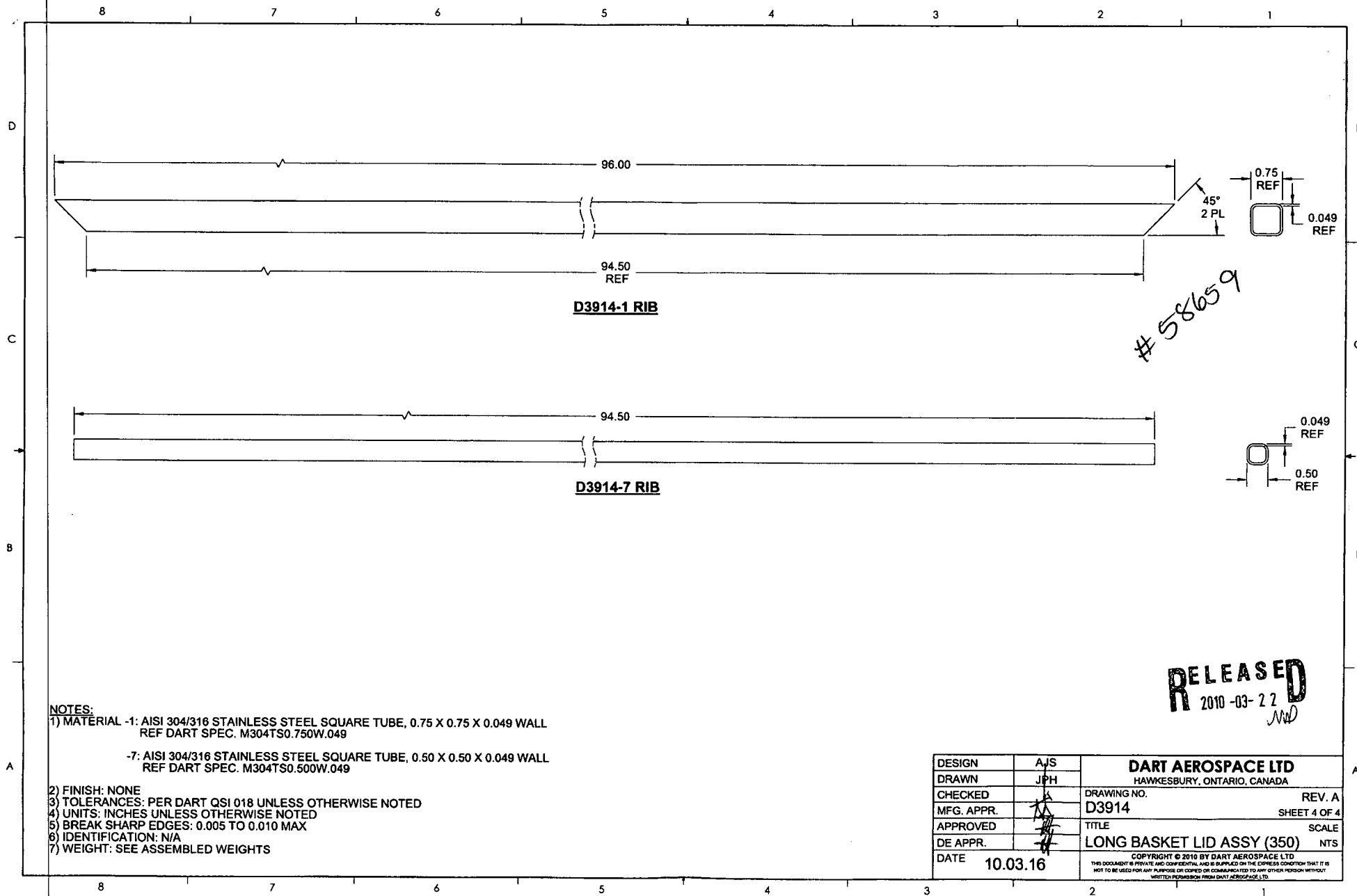
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